

①



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

**D3914-041**  
**Job Sheet 195759**



Part No: D3914-041

Job Qty: 1 pcs

Part Name: Long Basket Lid Assembly (350)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/30/19

Job Tracking No:

Due Date: 6/14/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

**Note:** DWG D4020 REV A SHEET 2, D3914 REV D SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC  
IPP Rev:B as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS PER DWG REV.pc1 DD  
VERF:JLM IPP REV:D 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

### Bill of Materials

### Job Routing

| Op<br>No | Operation              | Qty      | Start Date | Due<br>Date | Standard     |            | Workcenter/Supplier         |              | Sign-off    |
|----------|------------------------|----------|------------|-------------|--------------|------------|-----------------------------|--------------|-------------|
|          |                        |          |            |             | Setup<br>Hrs | Run<br>Hrs | Workcenter /<br>Supplier    | Lead<br>Time |             |
| 100      | Large Fab - Basket - 1 | 1<br>pcs | 6/14/19    | 0.00        | 10.00        |            | Large Fab - 1               |              |             |
|          |                        |          |            |             |              |            | Large Fab - 10              |              |             |
|          |                        |          |            |             |              |            | Large Fab - 2               |              |             |
|          |                        |          |            |             |              |            | Large Fab - 3               |              |             |
|          |                        |          |            |             |              |            | Large Fab - 4               |              |             |
|          |                        |          |            |             |              |            | Large Fab - 5               |              |             |
|          |                        |          |            |             |              |            | Large Fab - 6               |              |             |
|          |                        |          |            |             |              |            | Large Fab - 7               |              |             |
|          |                        |          |            |             |              |            | Large Fab - 8               |              |             |
|          |                        |          |            |             |              |            | Large Fab - 9               |              |             |
|          |                        |          |            |             |              |            | Large Fab - 11<br>(Various) |              |             |
| 110      | QC 9                   | 1<br>pcs | 6/14/19    | 0.00        | 0.00         |            | QC 9 - 10                   |              | JUN 25 2019 |
|          |                        |          |            |             |              |            | QC 9 - 18                   |              |             |
|          |                        |          |            |             |              |            | QC 9 - 24                   | DAS 24       |             |
|          |                        |          |            |             |              |            | QC 9 - 43                   | 9-89         |             |
|          |                        |          |            |             |              |            | QC 9 - 50                   |              |             |
|          |                        |          |            |             |              |            | QC 9 - 9                    |              |             |
| 120      | QC 5                   | 1<br>pcs | 6/14/19    | 0.00        | 0.00         |            | QC 5 - 10                   |              | JUN 25 2019 |
|          |                        |          |            |             |              |            | QC 5 - 12                   |              |             |
|          |                        |          |            |             |              |            | QC 5 - 17                   |              |             |
|          |                        |          |            |             |              |            | QC 5 - 18                   |              |             |
|          |                        |          |            |             |              |            | QC 5 - 19                   |              |             |
|          |                        |          |            |             |              |            | QC 5 - 22                   | DAS 24       |             |
|          |                        |          |            |             |              |            | QC 5 - 24                   | 9-89         |             |
|          |                        |          |            |             |              |            | QC 5 - 3                    |              |             |
|          |                        |          |            |             |              |            | QC 5 - 43                   |              |             |
|          |                        |          |            |             |              |            | QC 5 - 49                   |              |             |
|          |                        |          |            |             |              |            | QC 5 - 51                   |              |             |
|          |                        |          |            |             |              |            | QC 5 - 58                   |              |             |

Plex 5/30/19 10:30 AM Dart.lajeunesse.marie



|                                     |       |         |           |                          |           |  |
|-------------------------------------|-------|---------|-----------|--------------------------|-----------|--|
|                                     |       |         |           |                          | QC 5 - 68 |  |
|                                     |       |         |           |                          | QC 5 - 9  |  |
|                                     |       |         |           |                          | QC 5 - 50 |  |
|                                     |       |         |           |                          | QC 5 - 30 |  |
|                                     |       |         |           |                          | QC 5 - 40 |  |
| 130 Powdercoat - 4 Black Sand - B4B | 1 pcs | 6/14/19 | 0.00 0.40 | Powdercoat - 1 - B4B     |           |  |
|                                     |       |         |           | Powdercoat - 2 - B4B     |           |  |
|                                     |       |         |           | Powdercoat - 3 - B4B     |           |  |
|                                     |       |         |           | Powdercoat - 4 - B4B     |           |  |
| 135 QC 3                            | 1 pcs | 6/14/19 | 0.00 0.00 | QC 3 - 10                |           |  |
|                                     |       |         |           | QC 3 - 13                |           |  |
|                                     |       |         |           | QC 3 - 15                |           |  |
|                                     |       |         |           | QC 3 - 17                |           |  |
|                                     |       |         |           | QC 3 - 18                |           |  |
|                                     |       |         |           | QC 3 - 2                 |           |  |
|                                     |       |         |           | QC 3 - 28                |           |  |
|                                     |       |         |           | QC 3 - 3                 |           |  |
|                                     |       |         |           | QC 3 - 30                |           |  |
|                                     |       |         |           | QC 3 - 34                |           |  |
|                                     |       |         |           | QC 3 - 36                |           |  |
|                                     |       |         |           | QC 3 - 41                |           |  |
|                                     |       |         |           | QC 3 - 51                |           |  |
|                                     |       |         |           | QC 3 - 58                |           |  |
|                                     |       |         |           | QC 3 - 59                |           |  |
|                                     |       |         |           | QC 3 - 68                |           |  |
|                                     |       |         |           | QC 3 - 9                 |           |  |
|                                     |       |         |           | QC 3 - 40                |           |  |
|                                     |       |         |           | QC 3 - 19                |           |  |
|                                     |       |         |           | QC 3 - 43                |           |  |
|                                     |       |         |           | QC 3 - 24                |           |  |
| 140 Handfinish - 3-1- WingWalk- B4B | 1 pcs | 6/14/19 | 0.00 0.80 | Handfinish - 3 - 1 - B4B |           |  |
|                                     |       |         |           | Handfinish - 3 - 2 - B4B |           |  |
|                                     |       |         |           | Handfinish - 3 - 3 - B4B |           |  |
|                                     |       |         |           | Handfinish - 3 - 4 - B4B |           |  |
|                                     |       |         |           | Handfinish - 3 - 5 - B4B |           |  |
| 150 QC 3                            | 1 pcs | 6/14/19 | 0.00 0.00 | QC 3 - 10                |           |  |
|                                     |       |         |           | QC 3 - 13                |           |  |
|                                     |       |         |           | QC 3 - 15                |           |  |
|                                     |       |         |           | QC 3 - 17                |           |  |
|                                     |       |         |           | QC 3 - 18                |           |  |
|                                     |       |         |           | QC 3 - 2                 |           |  |
|                                     |       |         |           | QC 3 - 28                |           |  |
|                                     |       |         |           | QC 3 - 3                 |           |  |
|                                     |       |         |           | QC 3 - 30                |           |  |
|                                     |       |         |           | QC 3 - 34                |           |  |
|                                     |       |         |           | QC 3 - 36                |           |  |
|                                     |       |         |           | QC 3 - 41                |           |  |
|                                     |       |         |           | QC 3 - 51                |           |  |
|                                     |       |         |           | QC 3 - 58                |           |  |
|                                     |       |         |           | QC 3 - 59                |           |  |
|                                     |       |         |           | QC 3 - 68                |           |  |
|                                     |       |         |           | QC 3 - 9                 |           |  |
|                                     |       |         |           | QC 3 - 40                |           |  |
|                                     |       |         |           | QC 3 - 19                |           |  |
|                                     |       |         |           | QC 3 - 43                |           |  |

DAS  
15  
9-89DAS  
59  
9-89DAS  
59  
9-89

|                                 |          |         |      | QC 3 - 24                                   |                        |            |
|---------------------------------|----------|---------|------|---------------------------------------------|------------------------|------------|
| 160 Packaging 3-1 - Stock - B4B | 1<br>pcs | 6/14/19 | 0.00 | 0.00                                        | Packaging 3 - 1 - B4B  |            |
|                                 |          |         |      |                                             | Packaging 3 - 2 - B4B  |            |
|                                 |          |         |      |                                             | Packaging 3 - 3 - B4B  |            |
|                                 |          |         |      |                                             | Packaging 3 - 4 - B4B  |            |
|                                 |          |         |      |                                             | Packaging 3 - 5 - B4B  |            |
|                                 |          |         |      |                                             | Packaging 3 - 6 - B4B  |            |
|                                 |          |         |      |                                             | Packaging 3 - 7 - B4B  |            |
|                                 |          |         |      |                                             | Packaging 3 - 8 - B4B  |            |
|                                 |          |         |      |                                             | Packaging 3 - 9 - B4B  |            |
|                                 |          |         |      |                                             | Packaging 3 - 10 - B4B |            |
|                                 |          |         |      |                                             | Packaging 3 - 11 - B4B |            |
|                                 |          |         |      |                                             | Packaging 3 - 12 - B4B |            |
|                                 |          |         |      |                                             | Packaging 3 - 13 - B4B |            |
|                                 |          |         |      |                                             | Packaging 3 - 14 - B4B |            |
|                                 |          |         |      |                                             | Packaging 3 - 15 - B4B | ML 19.6-27 |
|                                 |          |         |      |                                             | Packaging 3 - 16 - B4B |            |
|                                 |          |         |      |                                             | Packaging 3 - 17 - B4B |            |
|                                 |          |         |      |                                             | Packaging 3 - 18 - B4B |            |
|                                 |          |         |      |                                             | Packaging 3 - 19 - B4B |            |
|                                 |          |         |      |                                             | Packaging 3 - 20 - B4B |            |
|                                 |          |         |      |                                             | Packaging 3 - 21 - B4B |            |
|                                 |          |         |      |                                             | Packaging 3 - 22 - B4B |            |
|                                 |          |         |      |                                             | Packaging 3 - 23 - B4B |            |
|                                 |          |         |      |                                             | Packaging 3 - 24 - B4B |            |
|                                 |          |         |      |                                             | Packaging 3 - 25 - B4B |            |
|                                 |          |         |      |                                             | Packaging 3 - 26 - B4B |            |
|                                 |          |         |      |                                             | Packaging 3 - 27 - B4B |            |
|                                 |          |         |      |                                             | Packaging 3 - 28 - B4B |            |
|                                 |          |         |      |                                             | Packaging 3 - 29 - B4B |            |
|                                 |          |         |      |                                             | Packaging 3 - 30 - B4B |            |
|                                 |          |         |      |                                             | Packaging 3 - 31 - B4B |            |
|                                 |          |         |      |                                             | Packaging 3 - 32 - B4B |            |
|                                 |          |         |      |                                             | Packaging 3 - 33 - B4B |            |
|                                 |          |         |      |                                             | Packaging 3 - 34 - B4B |            |
|                                 |          |         |      |                                             | Packaging 3 - 35 - B4B |            |
|                                 |          |         |      |                                             | Packaging 3 - 36 - B4B |            |
|                                 |          |         |      | Plex 5/30/19 10:30 AM Dart.lajeunesse.marie |                        |            |

ML 19-6-27



170 QC 21 - SA

1  
pcs

6/14/19

0.00 0.00

QC 21 - SA - 21

QC 21 - SA - 70

QC 21 - SA - 53

JUN 26 2019

DAS  
70  
9-89

Part Op 100 - (Weld per dwg A/R S.S. rod Batch: 13888) - 1- assemble ribs , weld as per dwg D3914 using DT9607A 2- weld  
 Descriptions: hinge (3) and Mounting brackets as per dwg D3914 \*\*\*Visual inspect before welding mesh\*\*\* 3- tack weld mesh on  
 basket as per dwg D3914 \*\*\*Cut out mesh where label plate goes in center off basket lid as per dwg D4020-5. Make sure  
 to place mesh correctly on lid, check with label plate before tacking mesh\*\*\*

110 - QC9- Inspect visual per QSI004- Fusion Welds

120 - QC5- Inspect part completeness to step on W/O

130 - Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 \*\*\* mask sides of hinge prior to powdercoat\*\*\*

135 - QC3- Inspect Part Finish

140 - Wing Walk as per dwg QSI005 4.4 Batch: 219-102 Mask data plate and apply wing walk on outside surface of  
 mesh as per dwg 2- Install label as per dwg \*\*\*Mask label plate to size of label, use scotchbrite red pad to lightly sand  
 area for label, apply label \*\*\*

150 - QC3- Inspect Part Finish

160 - Identify as per dwg &amp; Stock Location: \_\_\_\_\_

170 - QC21- Final Inspection - Work Order Release

Master Unit # 01034

## Job BOM

| Part / Item | Component Name                     | Quantity       | Operation                  | Container |
|-------------|------------------------------------|----------------|----------------------------|-----------|
| D2581 ✓     | Mounting Bracket                   | 2 pcs (2 ea) ✓ | 100-Large Fab - Basket - 1 | 5188852   |
| D3914-1 ✓   | Rib                                | 2 pcs (2 ea) ✓ | 100-Large Fab - Basket - 1 | 5179131   |
| D3914-7 ✓   | Rib                                | 2 pcs (2 ea) ✓ | 100-Large Fab - Basket - 1 | 5177106   |
| D4016-3 ✓   | Hinge Half, Lid                    | 3 pcs (3 ea) ✓ | 100-Large Fab - Basket - 1 | 5110937   |
| D4018-5 ✓   | Rib                                | 9 pcs (9 ea) ✓ | 100-Large Fab - Basket - 1 | 5177390   |
| D4020-5 ✓   | Mesh (350 Basket Long, Lid)        | 1 pcs (1 ea) ✓ | 100-Large Fab - Basket - 1 | 5181243   |
| D4021-3 ✓   | Data Plate                         | 1 pcs (1 ea) ✓ | 100-Large Fab - Basket - 1 | 5172801   |
| D4035-043 ✓ | Lid Rib Assembly, Aft (350 Basket) | 2 pcs (2 ea) ✓ | 100-Large Fab - Basket - 1 | 5183329   |

## Job Allocations

| Operation                  | Component Part | Required | Inventory | Allocated |
|----------------------------|----------------|----------|-----------|-----------|
| 100-Large Fab - Basket - 1 | D2581          | 2        | 2         | 0         |
|                            | D3914-1        | 2        | 10        | 0         |
|                            | D3914-7        | 2        | 10        | 0         |
|                            | D4016-3        | 3        | 36        | 0         |
|                            | D4018-5        | 9        | 58        | 0         |
|                            | D4020-5        | 1        | 11        | 0         |
|                            | D4021-3        | 1        | 39        | 0         |
|                            | D4035-043      | 2        | 14        | 0         |

## Part Specifications

Specifications could not be found.

Plex 5/30/19 10:30 AM Dart.lajeunesse.marie

Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                   |                                                                                                                                                                                                                                                                                                |                                                                                                                                                                                                                                                                                                                              |                                                                                                                                                                                                                                                                                                        |                                                                                                                                                                                                                                                  |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Job: _____<br><br>Part No. _____                                                                                                                                                                                                                                                                                                                                                        | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> | <b>DEPARTMENT/PROCESS</b>                                                                                                                                                                                                                                                                      |                                                                                                                                                                                                                                                                                                                              |                                                                                                                                                                                                                                                                                                        |                                                                                                                                                                                                                                                  |
|                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                   | Skid-tube <input type="checkbox"/><br>Machining <input type="checkbox"/><br>Large Fab <input type="checkbox"/>                                                                                                                                                                                 | Cross tube <input type="checkbox"/><br>Small Fab <input type="checkbox"/><br>Finishing <input type="checkbox"/>                                                                                                                                                                                                              | Eng. (Non-AW) <input type="checkbox"/><br>Prod. Eng. Coord. <input type="checkbox"/><br>Rec/Store/Packaging <input type="checkbox"/>                                                                                                                                                                   | Engineering <input type="checkbox"/><br>Water Jet <input type="checkbox"/><br>Supplier <input type="checkbox"/><br>Quality <input type="checkbox"/>                                                                                              |
| Date :                                                                                                                                                                                                                                                                                                                                                                                  | Sequence #:                                                                                                                       | QTY Affected :                                                                                                                                                                                                                                                                                 |                                                                                                                                                                                                                                                                                                                              |                                                                                                                                                                                                                                                                                                        | MRB (QSI042)                                                                                                                                                                                                                                     |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   | Disposition                                                                                                                                                                                                                                                                                    |                                                                                                                                                                                                                                                                                                                              |                                                                                                                                                                                                                                                                                                        | Completed By                                                                                                                                                                                                                                     |
|                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                   |                                                                                                                                                                                                                                                                                                |                                                                                                                                                                                                                                                                                                                              |                                                                                                                                                                                                                                                                                                        | Lead hand / Supervisor                                                                                                                                                                                                                           |
|                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                   |                                                                                                                                                                                                                                                                                                |                                                                                                                                                                                                                                                                                                                              |                                                                                                                                                                                                                                                                                                        |                                                                                                                                                                                                                                                  |
|                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                   |                                                                                                                                                                                                                                                                                                |                                                                                                                                                                                                                                                                                                                              |                                                                                                                                                                                                                                                                                                        | QC / QA Coordinator                                                                                                                                                                                                                              |
| <b>Root Cause</b><br><br>Operator <input type="checkbox"/><br>Manufacturing Process <input type="checkbox"/><br>Equip/Tooling <input type="checkbox"/><br>Handling/Preservation <input type="checkbox"/><br>Material <input type="checkbox"/><br>Product Improvement <input type="checkbox"/><br>Process Improvement <input type="checkbox"/><br>Human Factors <input type="checkbox"/> |                                                                                                                                   | <b>FAULT CATEGORY</b>                                                                                                                                                                                                                                                                          |                                                                                                                                                                                                                                                                                                                              |                                                                                                                                                                                                                                                                                                        |                                                                                                                                                                                                                                                  |
|                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                   | <input type="checkbox"/> Pressure/Forced<br><input type="checkbox"/> Bending<br><input type="checkbox"/> Crushing<br><input type="checkbox"/> Cracks<br><input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist<br><input type="checkbox"/> Marks/Chatter<br><input type="checkbox"/> Mislabeled | <input type="checkbox"/> Contamination<br><input type="checkbox"/> Misaligned/off center<br><input type="checkbox"/> BOM/Route<br><input type="checkbox"/> Broken/Damage/Defect<br><input type="checkbox"/> Incomplete/Unclear Instructions<br><input type="checkbox"/> Drill Holes<br><input type="checkbox"/> Fit/Function | <input type="checkbox"/> Power Loss/Surge<br><input type="checkbox"/> Folio/Program<br><input type="checkbox"/> Grain Direction<br><input type="checkbox"/> Weld<br><input type="checkbox"/> Wrong Stock Pulled<br><input type="checkbox"/> Out of Sequence<br><input type="checkbox"/> Off-set/Set-up | <input type="checkbox"/> Positioned Wrong<br><input type="checkbox"/> Outside Tolerance<br><input type="checkbox"/> Drawing<br><input type="checkbox"/> Finish<br><input type="checkbox"/> Part Lost/Missing<br><input type="checkbox"/> Misread |
|                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                   | Other/Details:                                                                                                                                                                                                                                                                                 |                                                                                                                                                                                                                                                                                                                              |                                                                                                                                                                                                                                                                                                        |                                                                                                                                                                                                                                                  |



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
CANADA  
TEL.: 1 613 632-6200  
Email: sales@dartaero.com  
www.dartaerospace.com

**Container No: S191729**



**Part: D3914-041**

**Job No: 195759**

**Serial No/Batch: S191729**

**Revision: A/D**

**Inspector:**

**Exp Date:**

**Instructions: Various STC's**

**Date: 06/19/19**